

Work Order ID 121925

121925

Page 1

Monday, July 14, 2014 10:46:34 AM

Item ID: D4494-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Upper Block Assembly, LH
Start Date: 7/7/2014 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 7/7/2014 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: CL Date: 14/07/14 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4494	D

100 0.00
100
Bandsaw
Jeaspa Bandsaw
Memo
CUT BLANK 6.6" LONG N/A
met supplied by
Archer.

110 0.00
110
Purchasing
Purchasing
Memo
ISSUE P/O: 24991
TO ARCHUR PRECISION(GLOBUS)
C OF C IS REQUIRED CL
CL 14/07/14 2.
P 14/8/14 (2)

120 0.00
120
QC
Quality Control
QC6- Inspect dimensions to drawing
Memo
5.14/08/14
(2)
DAS
38
9-8c
14/08/07

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Tuesday, July 08, 2014 8:57:24 AM

Page 3

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

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Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Work Order ID 121925

Tuesday, July 08, 2014 8:57:24 AM

121925

Page 4

Item ID: D4494-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Upper Block Assembly, LH
Start Date: 7/7/2014 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 7/7/2014 Req'd Qty: 2.00 ***2*** Customer:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Identify as per dwg & Stock Location: <u>5T230B</u>	0.00							
200									
Packaging	Memo	0.00							
Packaging									
210	QC21 - Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.00							
Quality Control									

2x DAS 28 9-89 AUG 14 2014

MLJ 14-08-19

14-8-19

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
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		<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

Picklist Print

Page 1

Monday, July 14, 2014 10:46:33 AM

Work Order ID: 121925

121925

Parent Item: D4494-041

D4494-041

Parent Item Name: Upper Block Assembly, LH

Start Date: 7/7/2014

Required Date: 7/7/2014

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 11-12-05 JLM VERIFIED BY:DD IPP
REV:B AS PER REV D JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MS20426AD3-4		Purchased	No			150	Each	5,680.000	4	8			
MS20426AD3-4										**	FF 14-08-13		
RIVET													

Location	Loc Qty	Loc Code
ST315	5680	
125578	3150	
m127432	2530	

M6061T6B1.000X04.00		Purchased	No			100	f	103.0490	0.55	2			
M6061T6B1.000X04.000										**	CL 14/08/19.		
6061-T6 Bar 1.00 x 4.00													

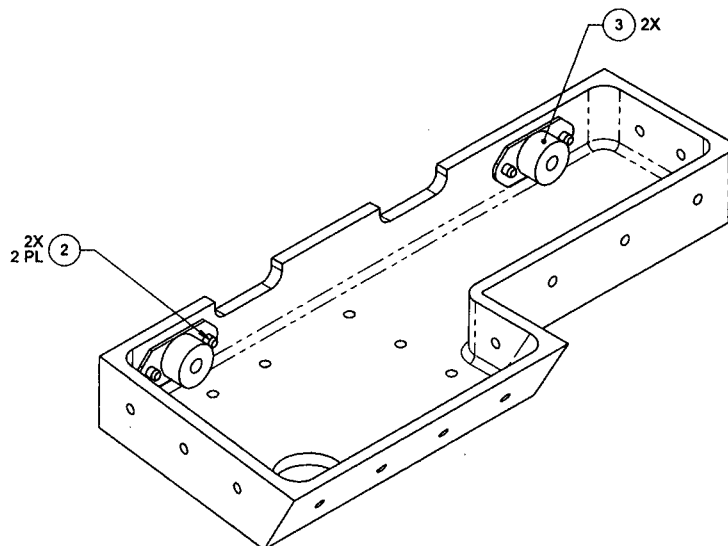
Location	Loc Qty	Loc Code
MAT003	103.049	
124681	23.7	
M126160	10	
M127797	20.349	
M128980	1	
M129167	48	

D4494-1P		Purchased	No			110	Each	0.0000	1	2			
D4494-1P										**	121925 7/4/17 (2)		
Upper Block Lower Door, LH													

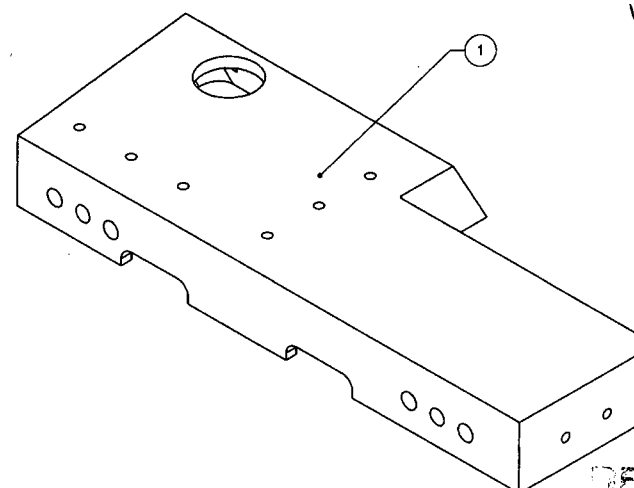
MS21059L08		Purchased	No			150	Each	544.0000	2	4			
MS21059L08										**	FF 14-08-13		
Nut													

Location	Loc Qty	Loc Code
ST508	544	
123185	1	
125654	543	

ITEM	QTY	P/N	DESCRIPTION
	X	D4494-041	UPPER BLOCK ASSEMBLY (LH)
1	1	D4494-1	UPPER BLOCK LOWER DOOR (LH)
2	4	MS20426AD3-4	RIVET, CSK
3	2	MS21059L08	NUTPLATE



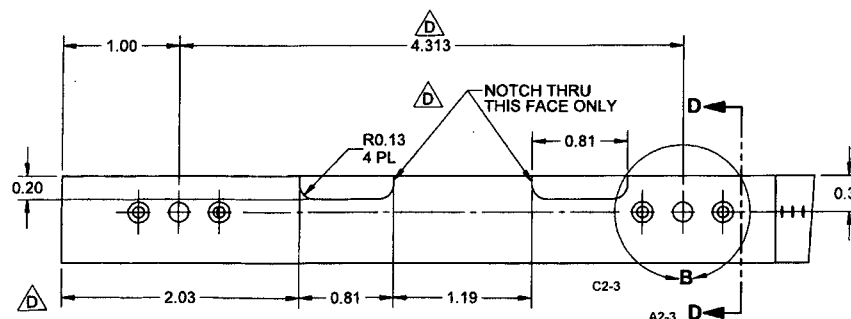
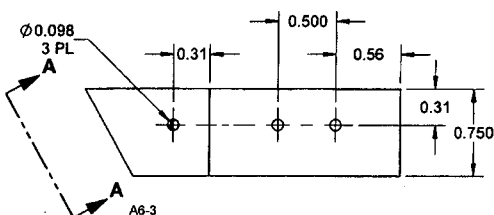
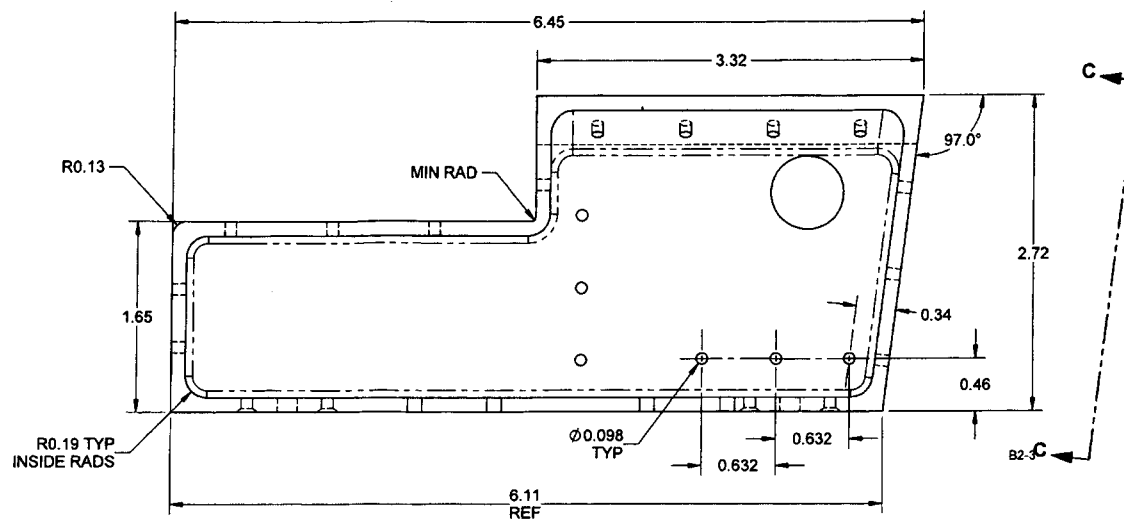
D4494-041 UPPER BLOCK ASSEMBLY (LH)



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 125925 MWS
140707

NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: NONE
7) WEIGHT: 0.30 lbs

D	B4-2, 4.313 DIM WAS 4.000. NOTCHES ADDED. B5-5 4.313 DIM WAS 4.000. NOTCHES ADDED. REASON: LATCH MECHANISM RELOCATED AT NEXT ASSY. MODIFICATIONS DONE TO CLEAR NUTPLATES.	AJS	12.12.12
C	ADDED -042 & -2 (RH CONFIGURATION)	AJS	12.10.23
B	COMPLETE REDESIGN SEE REV. A FOR DETAILS. PRIMER NOTE ADDED.	AJS	12.09.13
A	NEW ISSUE	AJS	12.03.02
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	A.P.	DRAWING NO.	REV. D
MFG. APPR.	2/1	D4494	SHEET 1 OF 6
APPROVED	1/0	TITLE	SCALE
DE APPR.	1/1	UPPER BLOCK ASSEMBLY	NTS
DATE	12.12.12	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



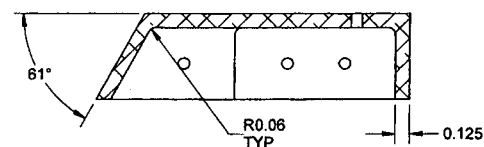
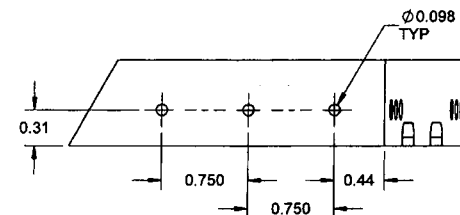
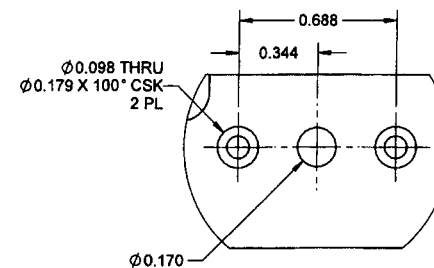
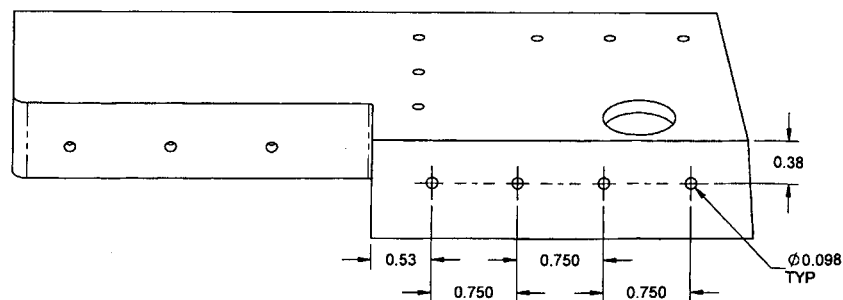
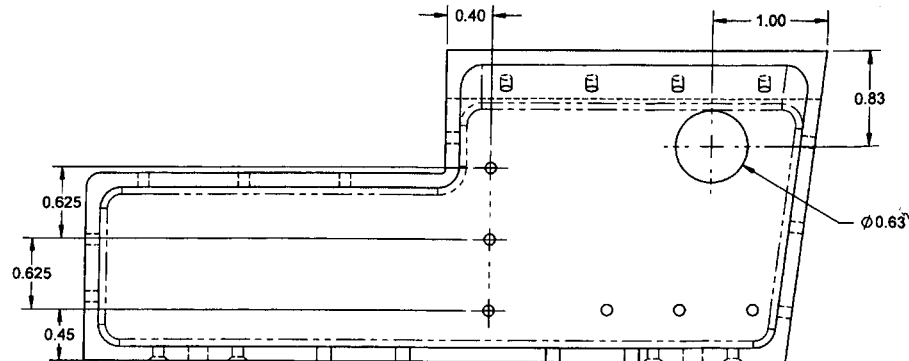
NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME TEMPO GREY (4.2.1.3.2) PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.28 lbs
- 8) RAW MATERIAL SURFACE FINISH SUFFICIENT FOR THIS PART
(NOT NECESSARY TO FACE MATERIAL)

D4494-1 UPPER BLOCK LOWER DOOR (LH)

RELEASED
2013-02-14

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. D
MFG. APPR.	AP	D4494	SHEET 2 OF 6
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	UPPER BLOCK ASSEMBLY	
DATE	12.12.12	NTS	
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THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



RELEASED
2013-02-14

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	AP	DRAWING NO. D4494	REV. D SHEET 3 OF 6
MFG. APPR.	AP	TITLE UPPER BLOCK ASSEMBLY	SCALE NTS
APPROVED	AP	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DE APPR.	AP		
DATE	12.12.12		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO24991

Purchase Order Date 7/14/2014

PO Print Date 7/14/2014

Page Number 1 of 2

Order From :

ARCHER PRECISION INC.
2228 GLADWIN CRESENT
OTTAWA, ON K1B 4S6
CA

VC-GLO001

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAXED

Contact Name

Vendor Phone 613 899 2405

Ship To Contact

Ship To Phone

Ship Via: FedEx PI ppd

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

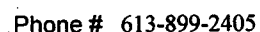
FOB

FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
	<u>Line Comments</u>		<u>Promise Date</u>				
	<u>Delivery Comments</u>						
1	D4494-1P	Upper Block Lower Door, LH	7/29/2014		2.00	\$223.00	\$446.00
			Yes		Each		
			7/29/2014				
	MACHINE AS PER DWG D4494 REV. D B121925						

Note:

7/14/2014



Date	Invoice #
8/6/2014	1113

Ship To
Main Finished Goods Location
Dart Aerospace
1270 Aberdeen Street
Hawksbury, Ontario
K6A 1K7

P.O. No.	Ship	Via	FOB	Project
24991	8/6/2014	delivered	Archer	

Qty	Item Code	Description
2	Sales	D4494-1P
2	Sales	D4494-2P
		HST (ON) on sales



2228 Gladwin Cres.
Ottawa, Ont.
K1B 4S6

Telephone (613) 899-2405
Fax (613) 226-1719

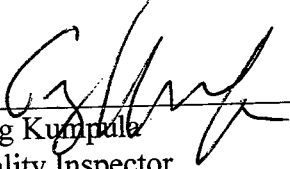
Certificate of Compliance

To:
Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury Ont.
K6A 1K7

6 Aug 2014

Po Number	Part Number	Quantities
24991	D4494-1P	2
	D4494-2P	2

It is hereby certified that all articles mentioned above are in conformance with the requirements, specification and drawings as listed on customer purchase order number, 24991 issued by Dart Aerospace Inc.



Greg Kumpula
Quality Inspector
Archer Precision Inc.
2228 Gladwin Cress.
Ottawa, Ontario
K1B 4S6

THYSSENKRUPP MATERIALS NA

ARCHER PRECISION INC.

ALUMINUM FLAT BAR 6061-T6511

1.00" x 3.00" X 6.7500"

PART NO.

PO/Rel 609

Nous certifions que le document reproduit ici est
une copie conforme du rapport fourni par le
producteur du materiel ou les donnees resultant de

Certificate of Mill Test Results

BL VIM-431896-004

25Jul14

Pg 1/1

l'analyse faite par un laboratoire qualifie.

SIGNE PAR: _____



LB ALUMINIUM BERHAD

(138535-V)

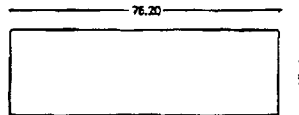


ALUMINIUM EXTRUSION

TEST CERTIFICATE

CUSTOMER : THYSSENKRUPP MATERIALS NA	SECTION NO. : PE01419MT03660	DATE : Apr-04-2014
SALES ORDER NO : 1406037	WORK ORDER : 401440	ALLOY : 6061-T6511
PRESS NO. : 3000	EXTRUSION DATE : Mar-26-2014	CERTIFICATE NO. : MCERT1403141
CUSTOMER PO NO. : VIM-625144		

Section Sketch :



Thickness = 25.40 mm

CHEMICAL COMPOSITION

Composition	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Al	Analysis Ref.-
Min	0.40	0.00	0.15	0.00	0.80	0.04	0.00	0.00	Remainder	U4A1105A
Max	0.80	0.70	0.40	0.15	1.20	0.35	0.25	0.15		Feb-02-2014
Actual	0.650	0.130	0.200	0.100	0.900	0.090	0.010	0.011		

MECHANICAL PROPERTIES (Result shown is tested by I.BALUM)

	Tensile Strength N/mm ²	Yield Stress N/mm ²	Elongation (%)
Standard	260	240	6
Result	367.25	343.53	16.80

Compliance with ASTM B221M-07

We hereby certify that the material covered by this report has been verified or tested according to the seller standard sampling method or the requirements of any specifications or requirements described herein, and that sample representative of the material met the composition limits and had the mechanical properties shown. Also, note that mercury is not a normal contaminant in aluminium alloys. Neither mercury nor any of its compounds are used in the manufacture of our extrusion. This certificate conforms to EN 10204.

** This certificate of Analysis has been produced electronically and is valid without signature **

Lot 11, Jalan Perusahaan 1, Kawasan Perusahaan Beranang, 43700 Beranang, Selangor Darul Ehsan, Malaysia.

Tel: 603-8723 8822 (15 Lines) Fax: 603-8723 3191 (General), 8723 7272 (Sales), 8727 1218 (Export)

Enquiry@lbalum.com.my www.lbalum.com



Archer Precision

Short date 8/6/14



Plan Name D4494-1_RevD

Part No.: D4494-1P

Customer: Dart Aerospace

Rev.: D

u_jobnum * u_jobnum *

u_qtynu * u_qtynu *

Customer PO.: * u_Cuspo *

BSN:

u_mtl * u_mtl *

Incr. Smpl No.: 1

Name	ID	Actual	Nominal	pos Tol	neg Tol	Diff	<-- -->
1 - OA Length	X	6.44499	6.44507	0.03000	-0.03000	-0.00008	-
2 - Egde	X	3.31869	3.32007	0.03000	-0.03000	-0.00138	-
3 - Angle of Side	A2	7.01766	7.00000	0.50000	-0.50000	0.01766	-
4 - OA Width	Y	2.72137	2.72137	0.03000	-0.03000	0.00000	
5 - Length	CartDist	6.10925	6.11000	0.03000	-0.03000	-0.00075	-
6 - Egde	CartDist	1.64589	1.65000	0.03000	-0.03000	-0.00411	-
7 - Exterior Radius	R	0.12462	0.12500	0.01000	-0.01000	-0.00038	-
8 - Interior Rad	R	0.18965	0.19000	0.01000	-0.01000	-0.00035	-
9 - XPosition Hole1	X	0.99751	0.99688	0.03000	-0.03000	0.00062	-
10 - YPostion Hole1	Y	0.83141	0.82693	0.03000	-0.03000	0.00448	-
11 - Diam_Hole1	D	0.62717	0.62500	0.00800	-0.00100	0.00217	--
12 - Angle Front	A2	-29.03105	-29.00000	0.50000	-0.50000	-0.03105	-
13 - Thickness	CartDist	0.12363	0.12500	0.01000	-0.01000	-0.00137	-
Pocket Depth	Z	-0.62569	-0.62500	0.01000	-0.01000	-0.00069	-

NOTES

1. HOLE SET 2, 3A, 3B, 3C ± 30 ALL VERIFIED CORRECT
BY HAND MEASUREMENTS /OK

2. CUTS MATCH CAD PROVIDED /OK